

384 . 375

Work Order ID 106314

106314

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August-28-13 11:48:25 AM

Item ID: D3907-1 Accept *N900040100* Setup Start *NS1*
Revision ID:
Item Name: Bushing Stop *NS2*
Start Date: 8/23/13 Start Qty: 80.00 *80* Cust Item ID:
Required Date: 8/28/13 Req'd Qty: 80.00 *80* Customer:

Reference: _____ Run Start *NR1*
Approvals: Process Plan: ML5 Date: 13-08-29 Tooling: _____ Date: _____ Stop
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3907	A	0.00							
100		0.00							
100									
Hardinge	Memo	0.00	DAS	40	13/09/04	80	0		
Hardinge CNC Lathe Small	Machine as per Folio FA823 & Dwg D3907		9-89						
	Dwg Rev: <u>A</u>								
	Folio Rev: <u></u>								
	Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00	DAS	40	13/09/04	80	0		
Quality Control			9-89						

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS									
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>									
NCR No. _____	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>	Quality <input type="checkbox"/>									
	Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Other <input type="checkbox"/>									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector				
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup															
Other															
Process															
Supplier															
Training															
Unapproved															
FAULT CATEGORY															
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio				<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	
														<input type="checkbox"/> Other	

Work Order ID 106314

106314

Page 2

August-28-13 11:48:25 AM

Item ID:	D3907-1	Accept	*N900040100*	Setup	Start	*NS1*	
Revision ID:				Stop		*NS2*	
Item Name:	Bushing						
Start Date:	8/23/13	Start Qty:	80.00	*80*	Cust Item ID:		
Required Date:	8/28/13	Req'd Qty:	80.00	*80*	Customer:		
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00 DAS 44 9-8	13/09/05						
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>WAC004</u> Memo *****STOCK IN BASKET CELL*****	0.00 0.00							80X 128 13-09-5
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							13/09/05

HP 094

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS									
Part No. _____			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>								
NCR No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>								
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>								
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector				
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup															
Other															
Process															
Supplier															
Training															
Unapproved															
FAULT CATEGORY															
Landing Gear	Bending <input type="checkbox"/>			General <input type="checkbox"/>			Grain <input type="checkbox"/>			Ovalized <input type="checkbox"/>			Pressure/Forced <input type="checkbox"/>		
	Centre Not Concentric to O/S <input type="checkbox"/>			BOM/Route <input type="checkbox"/>			Hardware <input type="checkbox"/>			Over/Under tolerance <input type="checkbox"/>			Temperature/Cure <input type="checkbox"/>		
	Cracks <input type="checkbox"/>			Broken/Damaged <input type="checkbox"/>			Inspection Incomplete <input type="checkbox"/>			Part Incorrect <input type="checkbox"/>			Weld <input type="checkbox"/>		
	Crushed/Crimped <input type="checkbox"/>			Burr <input type="checkbox"/>			Instructions Incomplete/Unclear <input type="checkbox"/>			Part Lost/Missing <input type="checkbox"/>			Wrong Stock Pulled <input type="checkbox"/>		
	Cuffs <input type="checkbox"/>			Contamination <input type="checkbox"/>			Maintenance <input type="checkbox"/>			Part Moved <input type="checkbox"/>					
	Heat Treat <input type="checkbox"/>			Countersink <input type="checkbox"/>			Mislabeled <input type="checkbox"/>			Positioned Wrong <input type="checkbox"/>					
	Inspection Strip in Tube <input type="checkbox"/>			Cut Too Short <input type="checkbox"/>			Misread <input type="checkbox"/>			Power Loss/Surge <input type="checkbox"/>					
	Ripples in Bend <input type="checkbox"/>			Drill Holes <input type="checkbox"/>			Offset <input type="checkbox"/>								
	Torque Waves in Extrusion <input type="checkbox"/>			Drawing <input type="checkbox"/>			Out of Calibration <input type="checkbox"/>								
	Turning Sequence <input type="checkbox"/>			Finish <input type="checkbox"/>			Out of Sequence <input type="checkbox"/>								
	Wave/Twist in Tube <input type="checkbox"/>			Folio <input type="checkbox"/>			Outside Dimensions <input type="checkbox"/>								

Picklist Print

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Page 1

Work Order ID: 106314

106314
D3907-1

Parent Item: D3907-1

Parent Item Name: Bushing

Start Date: 8/23/13

Required Date: 8/28/13

Start Qty: 80.00

Required Qty: 80.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375 *M304R0 375* 304 ROUND BAR 0.375		Purchased	No			100	f	35.1270	0.03	2.4	2.4	13/09/09	

Location	Loc Qty	Loc Code
MAT029	35.127	
125585 → MI26153	1.364	
	33.763	1.6

→ NO MATERIAL LEFT.

END OF BATCH.

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS														
Part No. _____	Work Order Update	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Machining <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/>	Quality <input type="checkbox"/>	Other <input type="checkbox"/>
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description			Sign & Date	Verification	QC Inspector							
Doc/Data																			
Equip/Tooling																			
Operator																			
Material																			
Setup																			
Other																			
Process																			
Supplier																			
Training																			
Unapproved																			
FAULT CATEGORY																			
Landing Gear	General				General				General				General						
	Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>														
	Centre Not Concentric to O/S <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>														
	Cracks <input type="checkbox"/>	Broken/Damaged <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>														
	Crushed/Crimped <input type="checkbox"/>	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>														
	Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>															
	Heat Treat <input type="checkbox"/>	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>															
	Inspection Strip in Tube <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>														
	Ripples in Bend <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>																
	Torque Waves in Extrusion <input type="checkbox"/>	Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>																
	Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>																
	Wave/Twist in Tube <input type="checkbox"/>	Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>																

DART AEROSPACE LTD	Work Order:	106314
Description: Bushing	Part Number:	D3907-1
Inspection Dwg: D3907	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

SAS

54

Measured by:	40	Audited by:	44	Preliminary Approval:	
Date:	13/09/04	Date:	13/09/05	Date:	

Rev	Date	Change	Revised by	Approved
A	09.05.20	New Issue	KJ	
B	10.06.07	Tolerance for dimension Ø0.375 revised	KJ	DD



8 7 6 5 4 3 2 1

D

D

C

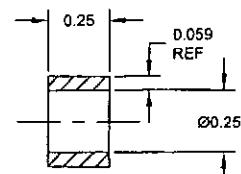
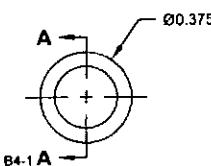
C

B

B

A

A



D3907-1 BUSHING

SECTION A-A C5-1

UNCL
S128
N. 106314 ML5
13-08-29

RELEASED
2010-11-14

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R

OR: AISI 304/316 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: N/A

A	NEW ISSUE	AJS	09.03.11
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3907	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BUSHING (BASKET REPAIR)	NTS
DATE	09.03.11	COPYRIGHT © 2009 BY DART AEROSPACE LTD ALL RIGHTS RESERVED AND CONFIDENTIAL. AND SHALL BE THE PROPERTY OF DART AEROSPACE LTD. NOT FOR USE OR DISSEMINATION OUTSIDE DART AEROSPACE LTD. AND NOT FOR USE IN THE DESIGN, MANUFACTURE, OR OPERATION OF AIRCRAFT.	

